

Blue

Dart Aerospace Ltd.

Date: Monday, 05/01/2009 7:58:25 AM  
 User: Linda Lacelle

## Process Sheet

|  |                                       |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services                                     | Drawing Name : 02.250 BLUE            |
| Job Number : 44371   |                                       |
| Estimate Number : 11057  |                                       |
| P.O. Number :  | Part Number : D28911                  |
| This Issue : 05/01/2009 S.O. No. :   | Drawing Number : D2891 REV A1         |
| Prsht Rev. : NC  | Project Number : N/A                  |
| First Issue : / / Type : PURCHASED PARTS   | Drawing Revision : A1                 |
| Previous Run : 43880   | Material :                            |
| Written By :   | Due Date : 31/01/2009 Qty: 6 Um: Each |
| Checked & Approved By : <u>JLD 08.01.05</u>  |                                       |
| Comment : Est. C 02.11.26 Added P/O KJ<br>Est D 08.03.19 Re-format EC verified: DD |                                       |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |                        |
|-----|--------|------------------------|
| 1.0 | DSK076 | D2891-1 TURNING DETAIL |
|-----|--------|------------------------|



Comment: Qty.: 0.5000 Each(s)/Unit Total : 3.0000 Each(s)  
 D2891-1 TURNING DETAIL  
 Batch: 42244

J.L 09/01/07

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS  
 Machine as per Folio FA046  
 Tumble & Deburr

J.L 09/01/07

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/01/07

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.F. 09/01/11 (6)

|     |                |                |
|-----|----------------|----------------|
| 5.0 | SPRAY PAINTING | SPRAY PAINTING |
|-----|----------------|----------------|



Comment: SPRAY PAINTING

--PRIME grey B 110199  
 --SPRAY PAINT DELFLEET BLUE B 110077  
 --CLEAR DELFLEET B 110161

ET 09-01-12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 05/01/2009 7:58:25 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 BLUE

Job Number: 44371

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC14

INSPECT SPRAY PAINT



ml 09 01 13



(6)

Comment: INSPECT SPRAY PAINT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 09-01-13

(x6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/14 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                                    |                |                             |
|------------------------------------|----------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>          |                | <b>Work Order:</b> 44371    |
| <b>Description:</b> Ø2.250 Support |                | <b>Part Number:</b> D2891-1 |
| <b>Inspection Dwg:</b> D2891       | <b>Rev:</b> A1 | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| HAAS Section  |       |       |                |                          |       |       |       |       |
| AA            | 0.188 | 0.193 |                | .189                     | .189  | .189  | .189  | .189  |
| AB            | 0.240 | 0.260 |                | .251                     | .249  | .252  | .249  | .250  |
| AC            | 0.115 | 0.150 |                | .124                     | .124  | .124  | .124  | 0.124 |
| AD            | 0.040 | 0.060 |                | .050                     | .051  | .050  | .051  | .050  |
| AE            | 0.010 | 0.020 |                | .015                     | .015  | .015  | .015  | .015  |
| AF            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AG            | 0.290 | 0.310 |                | .295                     | .295  | .295  | .295  | .295  |
| AH            | 0.115 | 0.150 |                | .137                     | .137  | .137  | .137  | .137  |
| AI            | 0.454 | 0.474 |                | .461                     | .461  | .462  | .461  | 0.461 |
| AJ            | 2.779 | 2.789 |                | 2.784                    | 2.784 | 2.784 | 2.784 | 2.784 |
| AK            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AL            | 1.002 | 1.042 |                | 1.035                    | 1.037 | 1.032 | 1.033 | 1.033 |
| AM            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AN            | 0.257 | 0.262 |                | .259                     | .259  | .259  | .259  | .259  |
| AO            | 1.663 | 1.683 |                | 1.673                    | 1.672 | 1.672 | 1.672 | 1.672 |
| AP            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AQ            | 0.022 | 0.042 |                | .032                     | .032  | .032  | .032  | .032  |
| AR            |       |       |                |                          |       |       |       |       |
| AS            |       |       |                |                          |       |       |       |       |
| AT            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

**Measured by:** J.L. **Date:** 09/01/07

**Audited by:** J.F. **Date:** 09/01/11

**Prototype Approval:** **Date:**

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 02.12.12 | New Issue | KJ/RF      |          |
| B   | 08.04.21 | Reformat  | KJ/JLM     |          |

|                             |         |                      |
|-----------------------------|---------|----------------------|
| DART AEROSPACE LTD          |         | Work Order: 144371   |
| Description: Ø2.250 Support |         | Part Number: D2891-1 |
| Inspection Dwg: D2891       | Rev: A1 | Page 1 of 1          |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |   |   |   |   |
|---------------|-------|-------|----------------|--------------------------|---|---|---|---|
| Dim           | Min   | Max   | Go/No Go Gauge | 6                        | 2 | 3 | 4 | 5 |
| HAAS Section  |       |       |                |                          |   |   |   |   |
| AA            | 0.188 | 0.193 |                | 0.189                    |   |   |   |   |
| AB            | 0.240 | 0.260 |                | 0.250                    |   |   |   |   |
| AC            | 0.115 | 0.150 |                | 0.124                    |   |   |   |   |
| AD            | 0.040 | 0.060 |                | 0.050                    |   |   |   |   |
| AE            | 0.010 | 0.020 |                | 0.015                    |   |   |   |   |
| AF            | 0.240 | 0.260 |                | 0.250                    |   |   |   |   |
| AG            | 0.290 | 0.310 |                | 0.295                    |   |   |   |   |
| AH            | 0.115 | 0.150 |                | 0.137                    |   |   |   |   |
| AI            | 0.454 | 0.474 |                | 0.461                    |   |   |   |   |
| AJ            | 2.779 | 2.789 |                | 2.784                    |   |   |   |   |
| AK            | 0.240 | 0.260 |                | 0.250                    |   |   |   |   |
| AL            | 1.002 | 1.042 |                | 1.033                    |   |   |   |   |
| AM            | 0.053 | 0.073 |                | 0.063                    |   |   |   |   |
| AN            | 0.257 | 0.262 |                | 0.259                    |   |   |   |   |
| AO            | 1.663 | 1.683 |                | 1.672                    |   |   |   |   |
| AP            | 0.053 | 0.073 |                | 0.063                    |   |   |   |   |
| AQ            | 0.022 | 0.042 |                | 0.032                    |   |   |   |   |
| AR            |       |       |                |                          |   |   |   |   |
| AS            |       |       |                |                          |   |   |   |   |
| AT            |       |       |                |                          |   |   |   |   |
| Accept/Reject |       |       |                |                          |   |   |   |   |

Measured by: JTP Date: 09/01/08

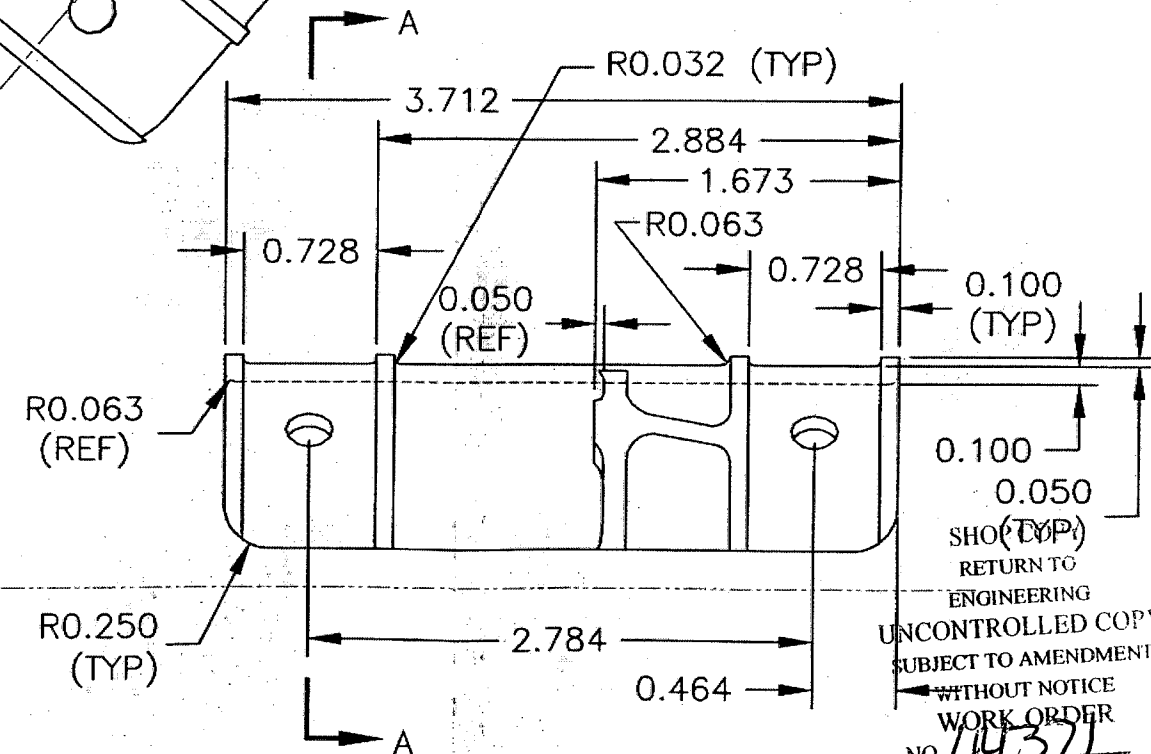
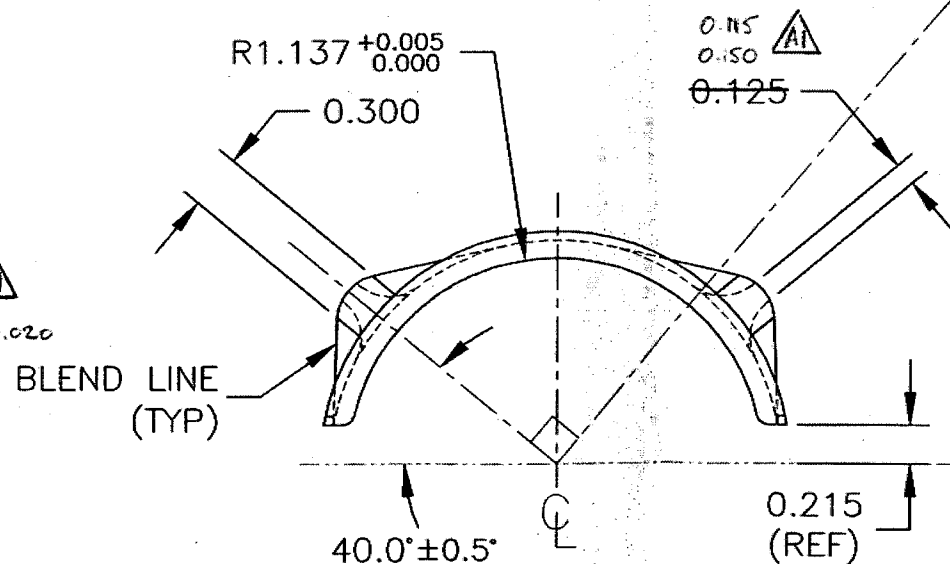
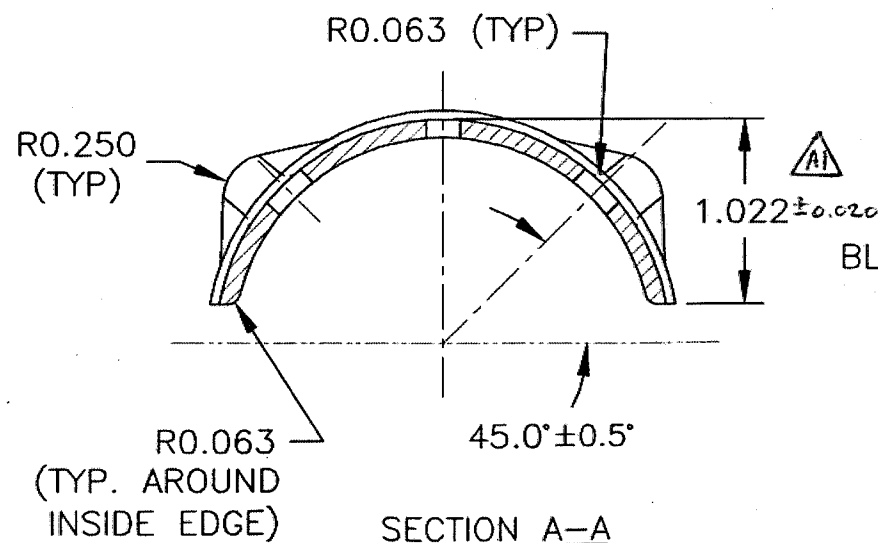
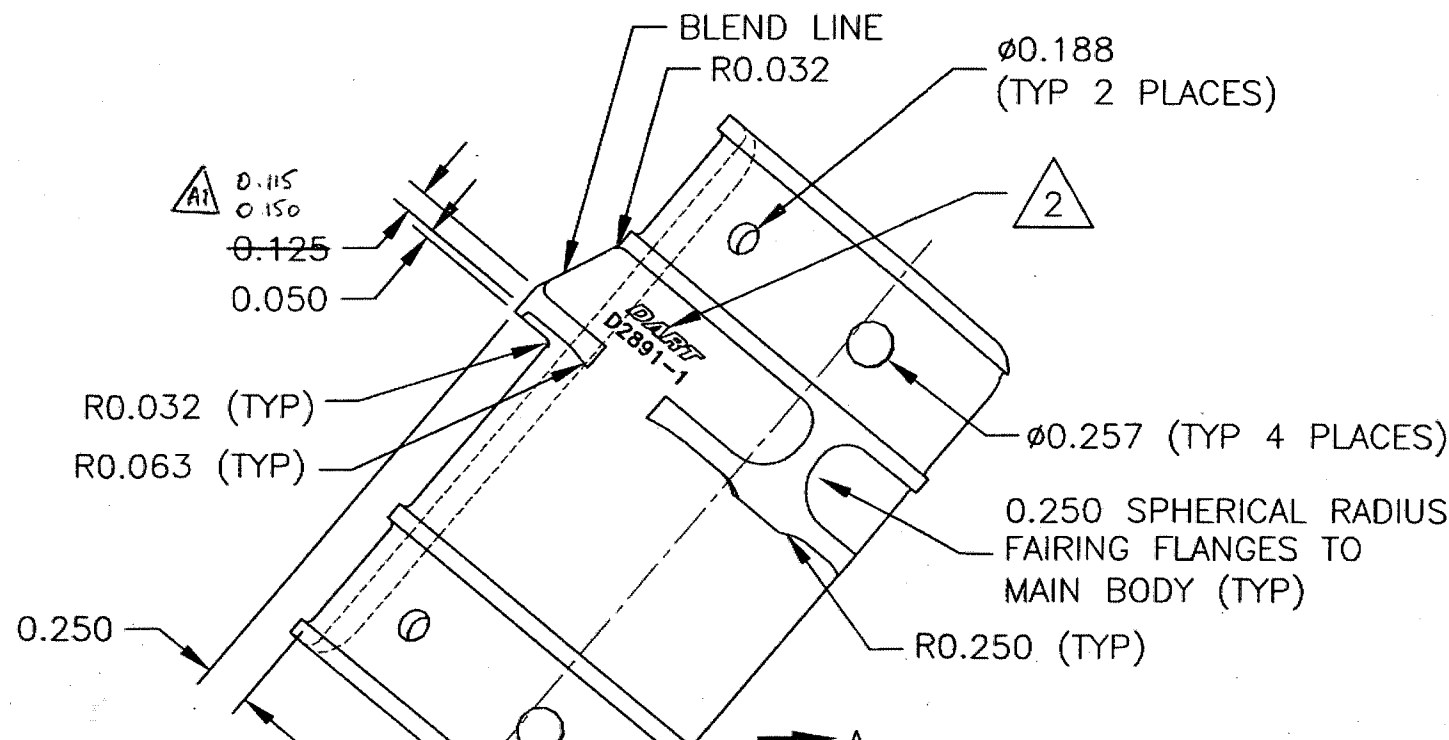
Audited by: J.F. Date: 09/01/11

Prototype Approval: Date:

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 02.12.12 | New Issue | KJ/RF      |          |
| B   | 08.04.21 | Reformat  | KJ/JLM     |          |

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



0.100  
0.050  
SHO (TYP)  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44371

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DART AEROSPACE LTD.

|         |             |  |
|---------|-------------|--|
| AI      | CP 02.01.23 | UPDATE DIMS AS MANUFACTURED.                       |
| A       | 00.11.17    | NEW ISSUE  |
| DESIGN  | CP          | DART   |
| CHECKED | CP          | DART AEROSPACE LTD.<br>HAWKESBURY, ONTARIO, CANADA |
| DATE    | 00.11.17    | DRAWING NO. D2891                                  |
|         |             | TITLE 0.250 SUPPORT                                |
|         |             | REV. A<br>SHEET 1 OF 1<br>SCALE 1:1                |